



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400214-1
Job Sheet R185746



Part No: RBT400214-1

Job Qty: 6 ea

Part Name: Frame Weld Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/6/18

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG RBT400214 Rev.7 IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		11/6/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	6 pcs		11/6/18	0.00	3.00	Large Fab 8	SPE NCR	EL
110	QC	6 pcs		11/6/18	0.00	0.00	QC9		PD 18-11-06
115	QC	6 pcs		11/6/18	0.00	0.00	QC5		PD 13-11-06
150	Outsource	6 pcs		11/6/18			ATG001-VC	5	PD 18-11-06
160	Packaging	6 pcs		11/6/18	0.00	0.00	Packaging2		NOV 08 2018
170	QC	6 pcs		11/6/18	0.00	0.00	QC6		NOV 12 2018
180	Packaging	6 pcs		11/6/18	0.00	0.00	Packaging3-2		MLL 9-89
190	QC21-SA	6 Ea		11/6/18	0.00	0.00	QC21		DAS NOV 12 2018

Part Op 100 - Weld -7, -9 and -11 as per DWG. Use fixture RBT400214-1-F.
Descriptions: 150 - -Issue P/O to ATG; PO 041617 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required
160 - Receive
180 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400214-7	Tab	6 Ea (1 ea)	90-Start up Operation	5/12/22
RBT400214-1	Frame Weld Mount	6 Ea (1 ea)	90-Start up Operation	5/096430

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT400214-1	6	6	0
			4	0



Container No: S124276



Part: RBT400214-1
Job No: R185746
Serial No/Batch: S124276

Revision: 7
Inspector:
Exp Date:
Instructions:

Date: 11/02/18

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211-112

211-112

1/2



Work Order NCR

Reviewed
DQA:
Date:

Printed on: Wednesday, October 31, 2018

Details

Raised Date 10/31/2018	Status Open	Owner Menard, Jean-Luc	Number NCR18-6996
Target Date	Standard	Severity	
Process Employee finding		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier)		Fault Category Lack of attention
Details RBT400214 S121922 was found with RBT400214-7 tab welded in the wrong orientation			
Keywords		Product RBT400214	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause

Target Date 11/10/2018	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action

Target Date 11/10/2018	Owner Menard, Jean-Luc	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
1	Lacelle, Linda	11/1/2018	
pull from stock qty 6 S121922 and re work as follow:remove and scrap -7 tab, replace by welding a new one, remove all finish using sandblast, inspection, outsource for red anodize.			

Implementing Corrective Action

Target Date	Owner	Closed Date	Closed By
11/10/2018			
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

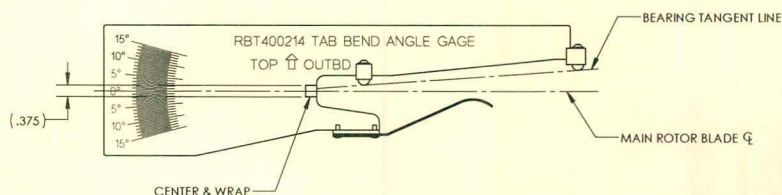
Verification & Review

Target Date	Owner	Closed Date	Closed By
	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

REV	QTY	ASBY QTY	B/O	Part #	UNIT	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
		X		-1		FRAME WELDMENT			1
				-3		DOUBLER	301 S.S.		3
				-5		SPRING CLIP	301 S.S.		4
		1		-7		TAB	6061		5
				-9		ADAPTER	6061		6
		1		-11		ADAPTER	7 6061		7
				-13		TAPE STOP	TEFLON	{PORT PLASTICS # 6093-10} MODIFIED	8
		1		-15		FRAME	6061		9
				-17		BEARING	BLACK NYLON/DELRI/ACETAL		10
				-19		TAPE FOR SPRING CLIP	TEFLON	{PORT PLASTICS # 6093-10} MODIFIED	11
		B/O	-21	4		RIVETS	ALUMINUM	Ø 1/8 X 3/8 (A1474A-4)	1
		B/O	-23	2		SELF THREADING PAN HEAD SCREW	STEEL	Ø 3/8 X 3/8 (MCMASTER-CARR #93878A146)	1
		B/O	-25	3		FLAT WASHER	STEEL	#6 (A190-6)	1
		ASBY	-27	1					

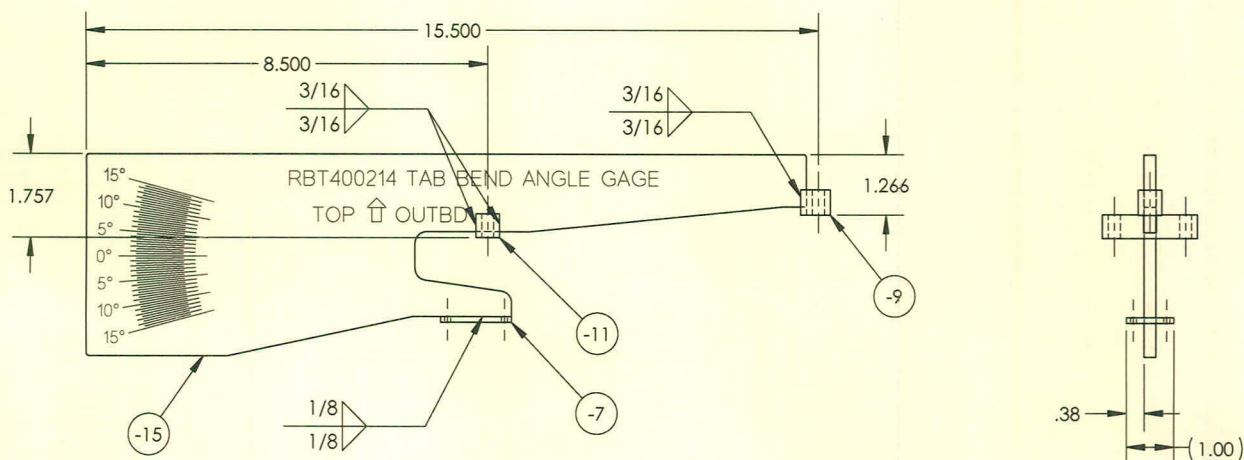
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NOTES:
1. APPLY -19 TAPE FOR SPRING CLIP TO -5 SPRING CLIP & -13 TAPE STOP TO -1 FRAME WELDMENT.
2. RIVET -3 DOUBLER & -5 SPRING CLIP TO -1 FRAME WELDMENT.
3. REF. BELL T/N: 407-215-002-101.

	
TRIM TAB BENDING GAUGE	
RTA400214	
DATE: REASON: FINISH:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX = .000 FRACTIONS = 1/8 .X = .1 ANGLES = ° .X.X = .1 SURFACES = 1/4"
DRAWN BY: COLE CHECKED: CLOUGH OFF APPR: ANDERSON APPROVED: LINDSAY SCALE: 1:1 DATE: 4/5/2001	1. BREAK ALL SHARP EDGES 2. USE .015" RADIUS 3. DIMENSIONAL LIMITS APPLY 4. USE .015" RADIUS AND TOL. PER 5. SEE 115-120-2000 USE ON MOCEL
SCALE: 1:1 DATE: 4/5/2001	BELL 4021 1 OF 11

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		CREATED -1 WELDMENT, ADJUSTED -11 POSITION UP .046 TO CORRECT ALIGNMENT.	10/30/2007	WP
2		ADJUSTED BEARING SUP .090 TO MATCH PURCHASED UNIT.	1/28/2008	WP
3		CH'D FINISH FROM POWDER COAT SAFETY YELLOW.	4/27/2011	RJC
3A		CH'D -1 FINISH FROM ANODIZE BLACK PER R.W.	8/25/2011	RJC
7	16-0240	-1 DELETED DIMS 15.250, 2.150, .089-.095, .203, 1.550, .694, (.190). ADDED DIMS .38, (1.00). ADDED FIXTURE RBT400214-1-F NOTE.	12/1/2016	DPD



NOTE:
USE FIXTURE RBT400214-1-F.

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214-1	REV 7
MAT'L HEAT TREAT FINISH SPEC DRAWN BY: CHECKED: OPFS APPR: QA APPR: APPROVED:	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .006 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
MIL-A-8625F, TYPE II, CLASS II COLE CLOUGH ANDERSON LINDSAY GILBERT	
USED ON MODEL BELL 407	
SCALE 1:3	DATE 4/9/2001
SHEET 2 OF 11	

(-1)
FRAME WELDMENT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041617**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041617

PO Date: 11/6/18

Due Date: 11/23/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173918	RBE350A94-3700-C-05	Bottom -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE- 2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700- C-05 Rev. 6 -Certificate of Conformity is required	Firmed	-	11/9/18	20 pcs	0 pcs	20 pcs	\$8.85/pcs	\$177.00

20 x

NOV 08 2018

[Signature]

Line Item Note ** NEED ASAP **

[Signature]

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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041617**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	R185746	RBT400214-1	Frame Weld Mount -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/23/18	4 pcs	0 pcs	4 pcs	\$8.85/pcs	\$35.40
Line Item Note * Only need this back by Nov. 23 ** 4 X NOV 08 2018											
3	173516	RBT400229-03	Right Side -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	11/23/18	10 pcs	0 pcs	10 pcs	\$8.85/pcs	\$88.50
Grand Total:											\$300.90

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916448

Date: 07-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery

Quantity	Description
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.
✓ 20 ea	Part: RBE350A94-3700-C-05 ✓ Rev: 6 Bottom Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 24042 PO: PO041617 ✓ Line: 1
✓ 4 each	Part: RBT400214-1 ✓ Rev: 7 Frame Weld Mount Anodize per MIL-A-8625F, Type II, Class 2, Red, Water Sealant, .0004-.0010" (.4 - 1 mils). Job: 24043 PO: PO041617 ✓ Line: 2
✓ 10 ea	Part: RBT400229-03 ✓ Rev: 2 Right Side Anodize per MIL-A-8625F, Type II, Class 1, Clear, Water Sealant, .0004-.0010" (.4 - 1 mils) Job: 24044 PO: PO041617 ✓ Line: 3

DAS
68
9-89

CERTIFICATE OF CONFORMANCE

A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.

Date: 7/11/18

Certified Signature: [Signature]

Receiver Signature: _____

A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

Made in Canada.

